

Work Order ID 144130

Tuesday, April 05, 2016 7:03:36 AM

144130

Page 1

Item ID: E4736-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Service Deck Drain Line Assembly

Start Date: 4/5/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/18/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
E4736	A								

100

0.00

100

Purchasing

Memo

0.00

Issue P/O: 31929

6 APR 05 2016

DAS
13
9-89

Fabricate as per dwg E4736

Purchase Part Number: E4736-3

Supplier: ~~FIELD AVIATION~~

Certificate of conformity is required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

6x 80/6-05-02

Tuesday, April 05, 2016 7:03:36 AM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 4/5/2016 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 4/18/2016 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	QC6- Inspect dimensions to drawing	0.00
-----	------------------------------------	------

120

OC

Quality Control

Memo

0.00

⑥ 16.03.03 DAS
9
9-89

Hand Finish Chemical Conversion coat
121 per Det \$51.00 4.1 0.00

121

121

Small Fab

Small Fab

Memo

0.00

CUT AND FLARE AS PER DWG
INSTALL NUTS BEFORE FLARING

1/2  MAY 04 2016

6 FF MAY 04 2016

122	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

122

OC

Quality Control

Memo

0.00

11

DAS
38
9-89

MAY 04 2016

Work Order ID 144130

Tuesday, April 05, 2016 7:03:36 AM

144130

Page 3

Item ID: E4736-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Service Deck Drain Line Assembly

Start Date: 4/5/2016 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 4/18/2016 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>Ship.</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

*6x 16-05-04**MCS* **MAY 04 2016***MCS***MAY 04 2016**

Tuesday, April 05, 2016 7:03:35 AM

144130

F4736-043

Start Date: 4/5/2016

Required Date: 4/18/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: : IPP REV:A NEW ISSUE 14-01-22 JLM VERIFIED BY:DD

AN818-10D	Purchased	No	Each	35.0000	6
AN818-10D					** DAS
Nut Coupling					30
					0.89
					MAY 04 2016

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST325	35	
121978	1	
122459	10	
m134606	24	

Manufactured No

F4736-3

Tube

MS20819-10J

Purchased	No
-----------	----

***MS20819-10.D**
sleeve

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST305	9	
123561	9	

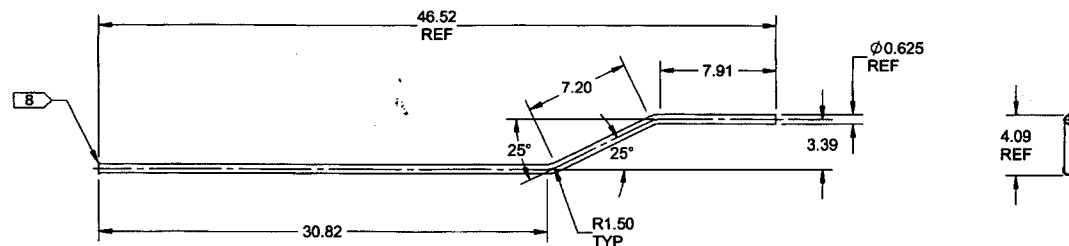
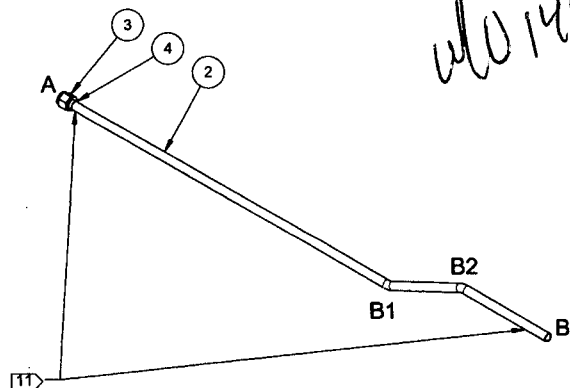
M122814⁹

**DAS
30
9-89**

MAY 04 2016

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	E4736-043	DRAIN LINE ASSEMBLY
2	1	E4736-3	TUBE
3	1	AN818-10D	NUT COUPLING
4	1	MS20819-10J	SLEEVE COUPLING

BEND #	BEND RADIUS (IN)	DISTANCE FROM END (IN)	BEND ANGLE (DEG)	PITCH (DEG)
END A	-	0.00	-	-
1	1.50	30.29	23.0°	0.0°
2	1.50	38.61	21.0°	174.0°
END B - TL	-	47.20	-	-



E4736-043 SERVICE DECK DRAIN LINE ASSEMBLY

E4736-3 TUBE

RELEASED
2013-11-28

NOTES:

- 1) MATERIAL: 6061-T4 ALUMINUM TUBING, $\phi 0.625 \times 0.035$ WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T4T0.625W.035
OR
5052-O ALUMINUM ROUND TUBING, $\phi 0.625 \times 0.035$ WALL
PER AMS-WW-T-700/4 OR ASTM-B-210-02
REF DART SPEC. M5052-OT0.625W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.42 lbs
- 8) FLARE TUBE PER MS33584
- 9) PRESSURE TEST TO 200 PSI
- 10) MARK LINE WITH BRADY B-999 "DRAIN" TAPE IN LOCATIONS SHOWN

DESIGN		EAGLE COPTERS LTD	
DRAWN		CALGARY, ALBERTA, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	E4736	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		DRAIN LINE	NTS
DATE	12.11.01	COPYRIGHT © 2012 BY EAGLE COPTERS LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31929

Purchase Order Date 4/5/2016

PO Print Date 4/5/2016

Page Number 1 of 2

Order From :

AGGRESSIVE TUBE BENDING
9750 - 188TH STREET
SURREY, B.C. V4N 3M2
CANADA

VC-ATB001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

APR 05 2016

Contact Name

Vendor Phone 604-882-4872

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

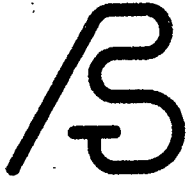
FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	E4736-3	Tube	4/14/2016 Yes 4/14/2016	FN	6.00 Each	\$119.92	\$719.52
	AS PER DWG E4736 REV. A B144130						
	Line Total:						\$719.52
2	71401-45	PROCUREMENT QUALITY CLAUSES	4/14/2016 No 4/14/2016		1.00	\$0.00	\$0.00
	Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A017 raw material identification (as applicable) A026 certification of conformance A040 notification of quality escape A041 quality management A042 dart noyification by supplier A043 retention of quality documents						

Note:

4/5/2016

**AGGRESSIVE TUBE BENDING INC.**

9750 188th Street
Surrey, BC V4N 3M2
Phone: 1-604-882-4872
Fax: 1-604-882-4873

PACKLIST

Packlist ID: **28213**
Date: **2016-04-22**
Page: **1 of 1**

Shipped By:**TERRY****Sold To Address**

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Ship To Address

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

CUSTOMER ID		CUSTOMER PO		PAYMENT TERMS		F.O.B.	
2883		PO31929		Net 30		OUR SHOP	
SALES REP ID		SHIPPING METHOD			SHIP DATE	OUR ORDER NUMBE	
YT		FEDEX 1-800-463-3339			APR 26/16	16-0422	
QUANTITY		CUSTOMER					
ORD	SHP	BCK	PART ID	DESCRIPTION	PART NO.	DRAWING #	

6 6 0

SUP/ANNEAL/BEND .625 X. 035 6061
T6

E4736 3

Rev: A

ORDER SPECIFICATIONS

RECEIVED BY: _____

QA REQUIREMENTS: Mill Test Reports

KAISER ALUMINUM FABRICATED PRODUCTS

Best in Class

CERTIFIED TEST REPORT
<http://Online.KaiserAluminum.com>

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

CUSTOMER PO NUMBER 61-31608-22		CUSTOMER PART NUMBER AT/ 625 035/734		PRODUCT DESCRIPTION Seamless Tube/Pipe	
KAISER ORDER NUMBER 217053	LINE ITEM 003	SHIP DATE 09/19/2014	KAISER LOT NUMBER F00172978	ALLOY 6061	TEMPER T6
WEIGHT SHIPPED 687.000 LB	QUANTITY 749.000 PCS	B/L NUMBER 216925	DIAM/DAF/THKNS	WIDTH	LENGTH 12.000 FT
SHIP TO MARMON/KEYSTONE CORP 32944 US HIGHWAY 6 SPRING VALLEY, IL 61362 USA			SOLD TO MARMON/KEYSTONE CORP 1000 REMINGTON BLVD SUITE 305 BOLINGBROOK, IL 60440 USA		

Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CON%IACS	BEND
F00172978	0001	1	47.6	44.6	12.5	N/A	N/A	N/A
F00172978	0002	1	47.2	44.1	13.5	N/A	N/A	N/A
F00172978	0003	1	49.4	45.8	13.0	N/A	N/A	N/A

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
D73277	.63	.31	.25	.06	1.00	.10	.09	.03	.00	.00	.00	.01	.02

Applicable Requirements:

Description: MADE IN USA
OD: 0.625"; Wall: 0.035"; Round @
AMS-4082P ASTM B210-12 WW-T-700/6F
WE TAKE EXCEPTION TO PARA. 5.2.1., Per AMS-4082P, WAS NOT OILED.
COMPLIES TO DIN EN 10204 JAN 2005
COMPLIES TO DFAR 252.225-7001 and DFAR 252.225-7014
No Weld Repair. Mercury Free.

Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

Plant Serial: 00017937
Kaiser Order Number: 217053
Line Item: 003

**KAISER
ALUMINUM**
FABRICATED PRODUCTS

Best in Class

CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
6573 W WILLIS ROAD
CHANDLER, AZ 85226

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file subject to examination.

Nathaniel Stevens, Quality Manager



QC REVIEWED

JAN 26 2015